

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005441**Date Inspected:** 18-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Mr. Chung Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

Witness Procedure Qualification Record (PQR) qualification test (test plate SW-7-2): Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau, travel to Japan Steel Works (JSW) Muroran plant to witness an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-10 (test plate SW-7-1). The PQR qualification test utilizing Shielded Metal Arc Welding (SMAW) was conducted by welder Mr. Kouzou Kobayashi (08-5023) performed in the flat position (1G). The material used for the PQR qualification test specimens was reported by JSW Welding Engineer Mr. Takaaki Maruya as A148M-Gr.550-345 and ASTM A709-Gr.345T (casting to plate) having a wall thickness measurement of 50mm. The weld joint design used butt joint, single-V-groove weld with 20mm x 75mm backing bar. The filler metal used in the test is TB52A with 4mm diameter electrode, made by Kobelco Japan. The SMAW welding and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, and JSW Welding Engineer Mr. Takaaki Maruya, and were also observed by Caltrans QAI. Filler weld passes (#48 to #56) were completed on this date. The preheat temperature of the test plate is to be held at 120 C overnight for the continuation of the welding at tomorrow. Based on Caltrans QA observation, no discrepancies were noted.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
